

Date: Thursday, 25/10/2007 2:34:52 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 35400  
Estimate Number : 11155  
P.O. Number : *N/A*  
This Issue : 25/10/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 28618  
Written By : \_\_\_\_\_  
Checked & Approved By : \_\_\_\_\_  
Comment : Est. A 05.03.14 New issue KJ/JLM

Drawing Name : SHAFT SLEEVE  
Part Number : D32337  
Drawing Number : D3233 REV B  
Project Number : N/A  
Drawing Revision : B  
Material : *N/A*  
Due Date : 01/11/2007

Qty: 14 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M1020TR1375W125 COLD DRAWN ROUND TUBE



Comment: Qty.: 0.1860 f(s)/Unit Total : 2.6034 f(s)  
1020-1025 Round Tube  
Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020  
SRA or AMS 5075 or AMS 5077  
(M1020TR1.375W.125)  
Identify for D3233-7  
Batch: *M103258*

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONV.LATHE  
Turn as per Dwg D3233

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
Deburr

*Not Required*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 35400

Part Number: D32337

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 2/10/26*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS23*

*CARL*

*Pl 07-10-29*

*(4)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(4)*  
*Dor/dar*

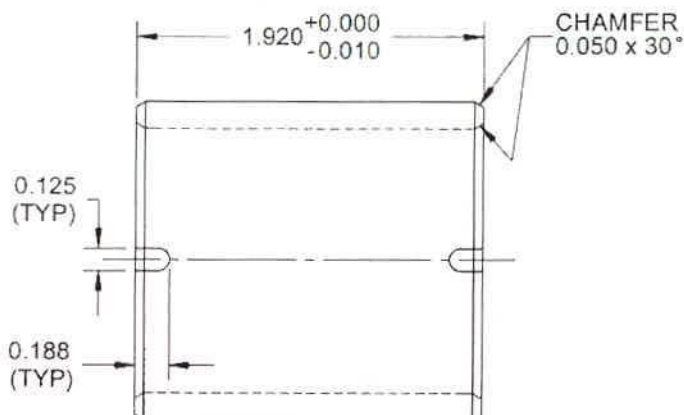
Job Completion



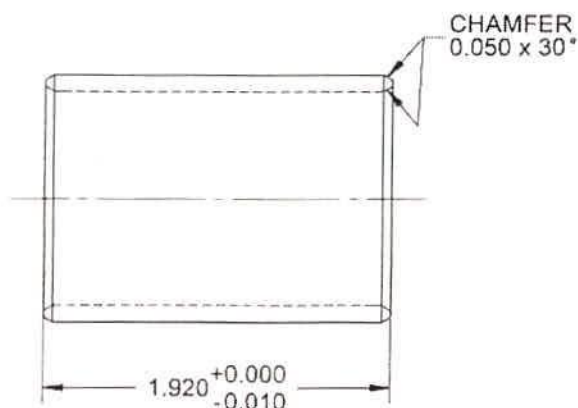
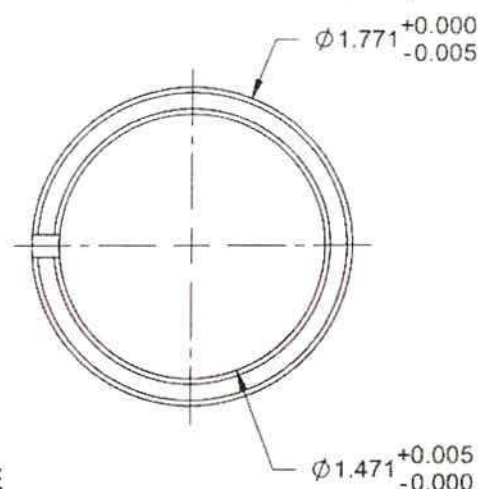
*12 07-10-29*



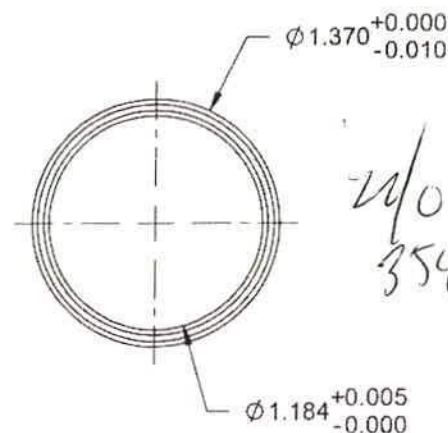
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.




DART AEROSPACE LTD		Work Order: 35400
Description: <del>Cross tube Assembly</del> shaft sleeve		Part Number: D3233-7
Inspection Dwg: D3233	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	1.920	+0.000 -0.010	1.919	✓			
	1.370	+0.000 -0.010	1.369	✓			
	1.184	+0.005 -0.000	1.185	✓			
	0.050 X 30°	+0.010 ±1/2°	0.050 X 30°	✓			
SIDE B							

Measured by: 	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/10/26	Date: 07/10/26	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved

